

Work Order ID 79348

79348

Page 1

Wednesday, January 25, 2012 12:00:43 PM

Item ID: D3264-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 1/25/2012 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 2/3/2012 Req'd Qty: 5.00 ***5*** Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/01/25 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3264	<u>Rev A2</u> <u>A</u> <u>12/01/25</u>

100

0.00

100

Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 5.700" LONG

0.00

SL 12-02-15

(S)

110

0.00

110

HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOILIO FA447

FOLIO REV: AA

DWG REV: A

DEBURR AS PER DWG

0.00

PO/BA 12/03/07

SL 12-03-8

(S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79348

Wednesday, January 25, 2012 12:00:43 PM

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Item ID: D3264-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 1/25/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 2/3/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

PO/Ba 12/03/07

SL 12/03-08

5 0 _____

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

SL 12/03/08

5 0 _____

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

SL 12/03/08

W/O:		WORK ORDER CHANGES					
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79348

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N900040100

Setup Start *NS1*

Stop ***NS2***

Cust Item ID:

5

5

Customer:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

79348

Wednesday, January 25, 2012 12:00:43 PM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

5

Cust Item ID:

Start Date: 1/25/2012 **Start Qty:** 5.00

Required Date: 2/3/2012 **Req'd Qty:** 5.00

5

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

180

QC21- Final Inspection - Work Order Release

0.00


180

QC

Memo

0.00

Quality Control

Qty	Number	Stamp
12	13/16	

112-03-14

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, January 25, 2012 12:00:47 PM

Work Order ID: 79348

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Parent Item: D3264-1

D3264-1

Parent Item Name: Bracket

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP A04.09.02New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6B1.250X04.50

Purchased

No

f

8.7417

2.5

0

M6061T6B1 250X04 500

**

SL 12-02-15

6061-T6 Bar 1.25 X 4.50

Location

Loc Qty

Loc Code

MAT004

8.7417

112628

0.7417

119230

8

2.5

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	79348
Description: Bracket		Part Number:	D3264-1
Inspection Dwg: D3264 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	0,687	✓		VERN	GA-09
0.063	+/-0.010	0,062	✓		VERN	GA-09
0.125	+/-0.010	0,125	✓		MIC	118-120
0.875	+0.010/-0.020	0,875	✓		VERN	GA-09
0.062	+/-0.010	0,061	✓		VERN	GA-09
R0.03	+/-0.030	0,030	✓		R-G	ref.
R0.13	+/-0.030	0,130	✓		"	"
1.00	+/-0.030	1,000	✓		VERN	GA-09
0.125	+/-0.010	0,125	✓		MIC	118-120
0.600	+/-0.010	0,601	✓		VERN	GA-09
4.000	+/-0.005	4,000	✓		VERN	GA-09
0.750	+/-0.010	0,750	✓		VERN	GA-09
Ø0.194	+0.005/-0.000	0.195	✓		Pin gage	
5.50	+/-0.030	5,500	✓		VERN	GA-09
0.125	+/-0.010	0,125	✓		VERN	GA-09
0.063	+/-0.010	0,065	✓		MIC	118-120
R0.25	+/-0.030	0,250			R-G	Ref
4.27	+/-0.030	4,27	✓		VERN	GA-09
R0.30	+/-0.030	0,30	✓		R-G	Ref

Measured by:	D / BA	Audited by:	anf	Prototype Approval:	N/A
Date:	12/03/07	Date:	12/03/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

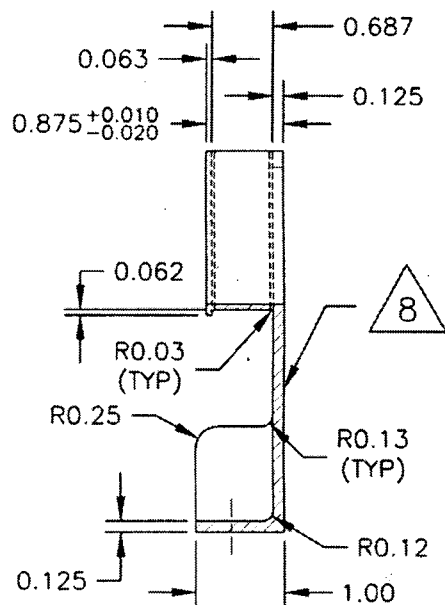
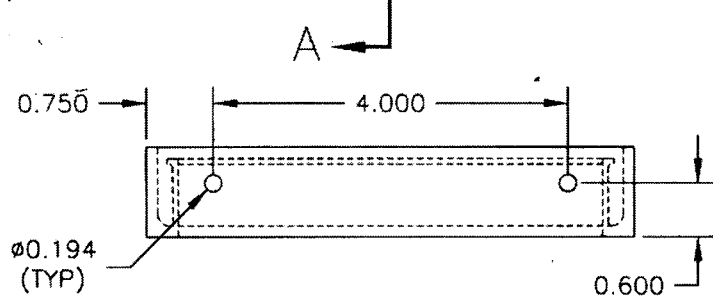
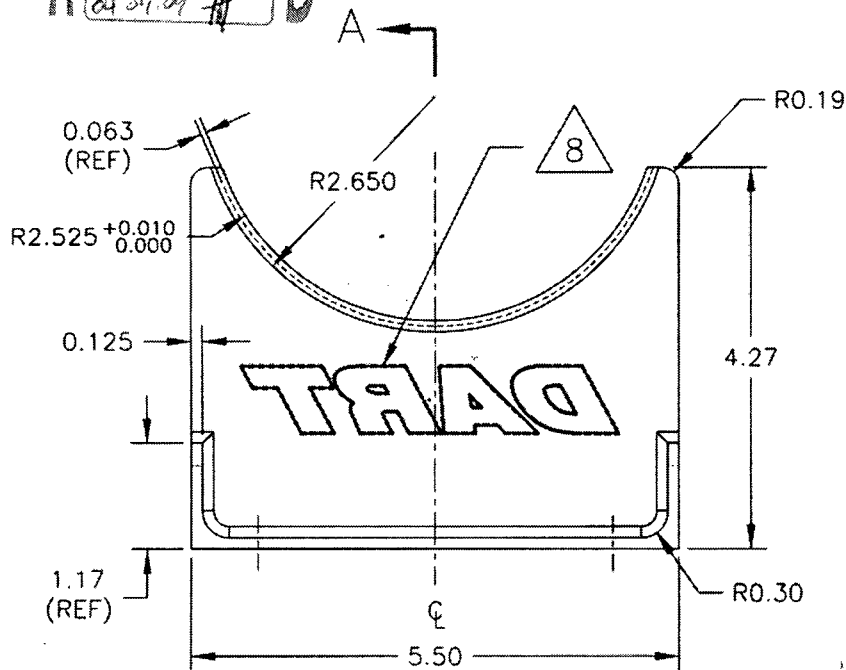
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DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20	TITLE BRACKET		SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED
04.04.20 #



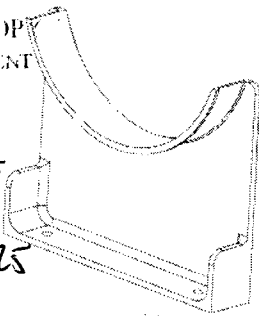
SECTION A-A

COPY
RNTD
RING
OILED COPY
OAVEMENT
T NOTICE
KORER

79348

ML3

12/01/25



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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